

Date: Tuesday, 3/11/2008 7:57:28 AM
 User: Kim Johnston

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 37745 2
 Estimate Number : 10255
 P.O. Number :
 This Issue : 3/11/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : MACHINED PARTS
 Previous Run : 36747
 Drawing Name : MOUNTING LUG
 Part Number : D22301
 Drawing Number : D2230 REV F
 Project Number : N/A
 Drawing Revision : F
 Material :
 Due Date : 3/31/2008 Qty: 200 Um: Each
 Written By :
 Checked & Approved By : EF 08/03/11
 Comment : Est D 0011.01 Added inspection level 8, and removed P/O for powder coat EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total: 7.1715 f(s)

Lug Extrusion D2423 Extrusion

Batch: B33310C208/03/12(1.1715)

2.0 BAND SAW

BAND SAW



Comment: BAND SAW

Cut D2423 extrusion to 0.82"

Batch: N/Ametric as per drawingREV FC208/03/12(200)

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine per folio D2230-1

(Check for crack while loading into the machine.)

2-Tumble and deburr rough edges after tumbling

N/A10/3/20(80)rec'd + inspect for damage

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC2

SECOND CHECK



Comment: SECOND CHECK

08/03/06(180)count5.1 Tumble -EF 08/03/28(80)

Tuesday, 3/11/2008 7:57:28 AM
Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 37745

Part Number: D22301

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(80)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

LR 08-03-31

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/31 (80)

8.0

POWDER COATING

POWDER COATING



(80X)

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

M-L 08/03/31

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

AS FL 08/04/01 (80)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51476

AS 08/04/02 (80)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/03 (80)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

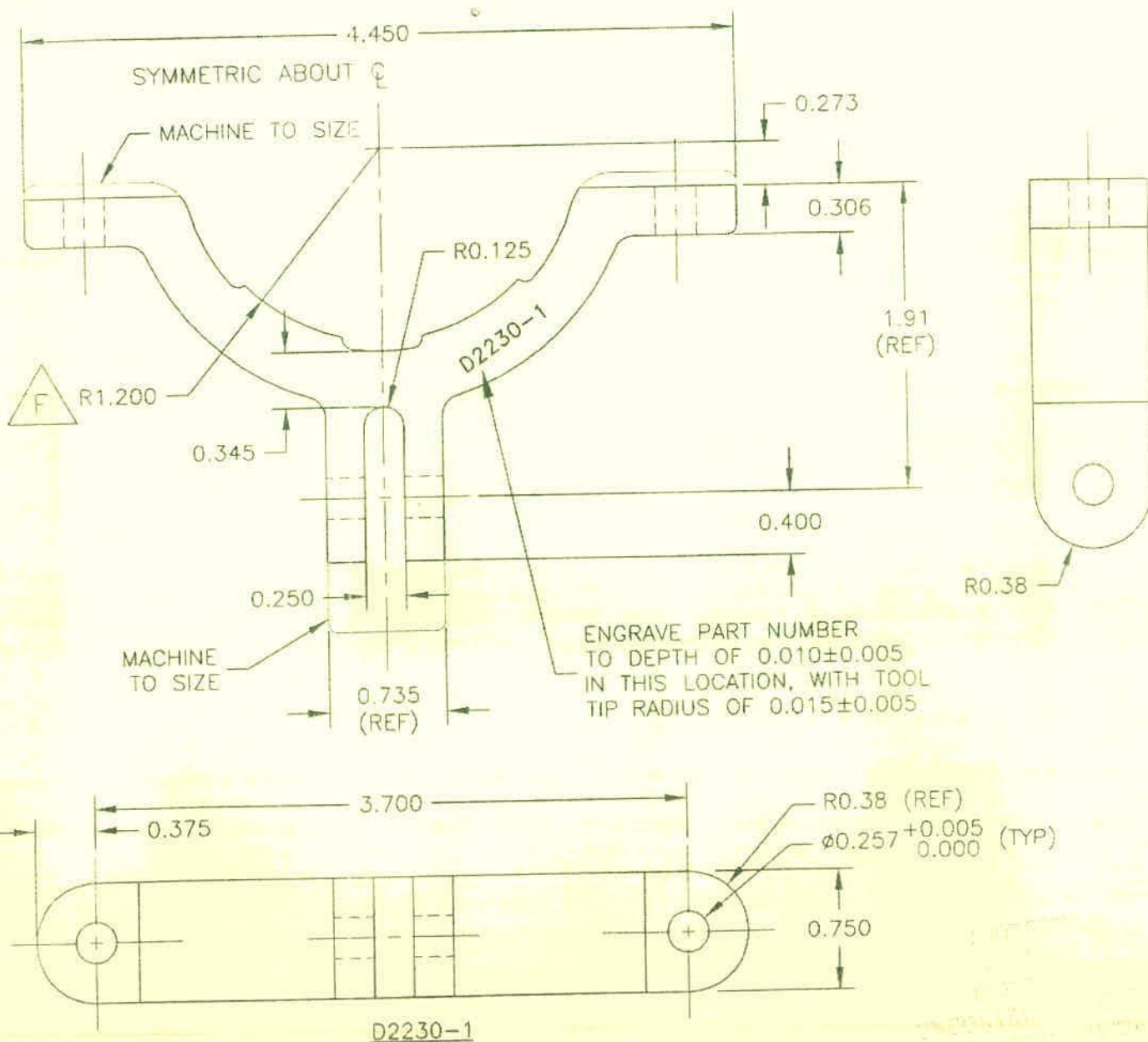


W 08-04-02



DESIGN <i>CP</i>		DRAWN BY <i>CP</i>		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HT</i>		APPROVED <i>HT</i>		DRAWING NO. D2230	
DATE 99.12.13		TITLE MOUNTING LUG		REV. F SHEET 1 OF 2	
C	94.03.30	RE-DESIGN			
D	95.01.04	RE-DESIGN			
E	95.01.04	RE-DESIGN			
F	99.12.13	REDESIGN; R1.200 WAS R1.100			

RELEASED
70 12 21 05

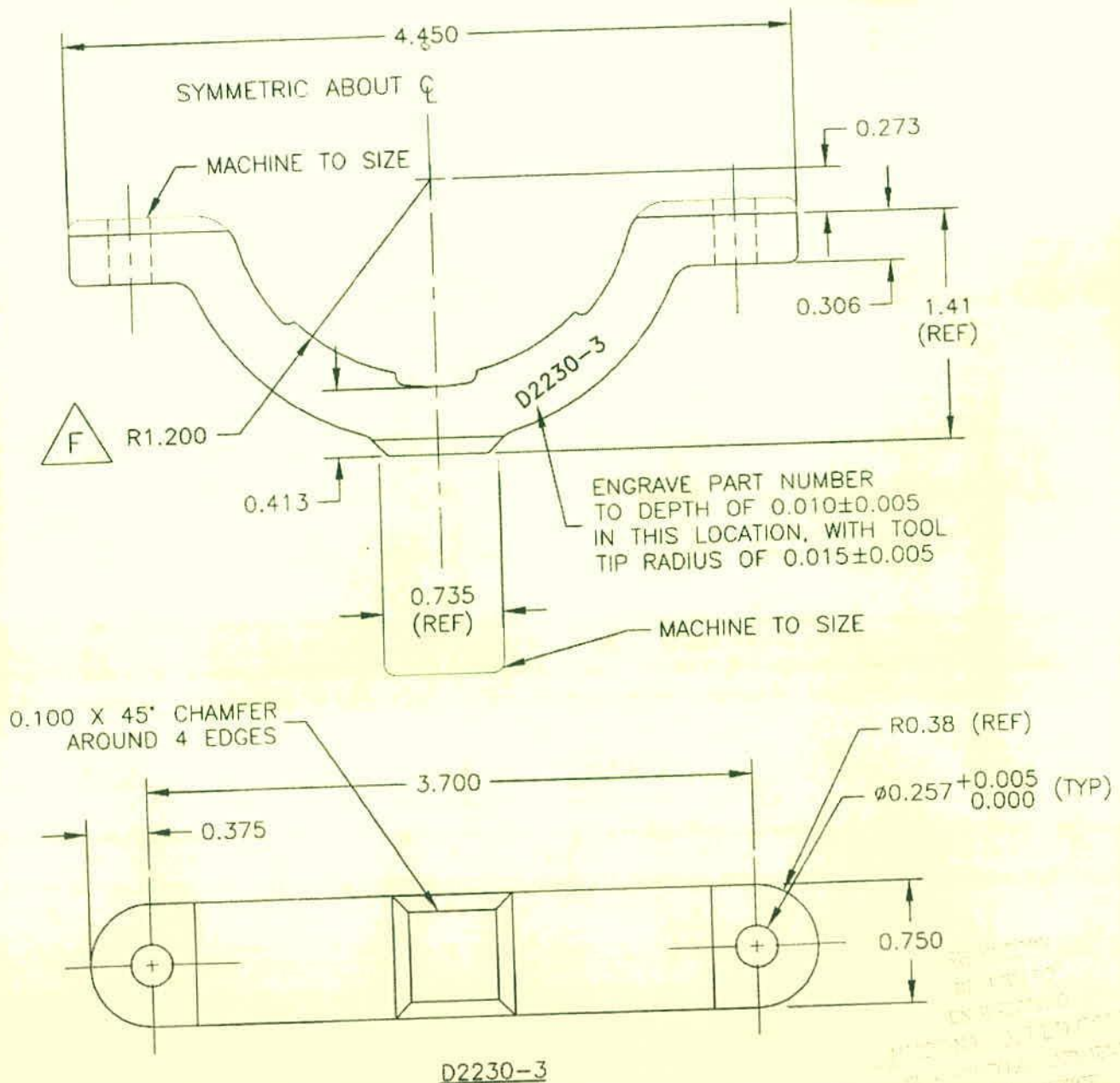


MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

37745

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. SHEET 2 OF
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1

RELEASED
17 12 20 05

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

80

D2230-1

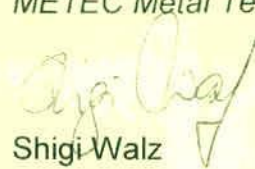
Lug B37745

5896

MATERIAL: supplied by DART D2423 B33310

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, March 26, 2008

